

Work Order ID 84536

Tuesday, May 15, 2012 12:48:43 PM

84536Ship fumer ^{aw}

Page 1

Item ID: DSI 9342-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Gusset Repair, Quick Release

Stop ***NS2***

Start Date: 5/15/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/16/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

12-05-15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

DSI 9342

B

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9342-013
CHG001

0.00

0.00

*8 vatos/16**MLC 12/05/16*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

*1/k**SP
12-5-16*

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

8 vatos/16

Work Order ID 84536***84536***

Page 2

Tuesday, May 15, 2012 12:48:43 PM

Item ID: DSI 9342-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Gusset Repair, Quick Release

Stop ***NS2***

Start Date: 5/15/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/16/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9342-013

Location:

PPP rev: *Draft**6/5/16*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*MLJ 12/05/16**mk 12-05-16*

Picklist Print

Tuesday, May 15, 2012 12:48:43 PM

Page 1

Work Order ID: 84536

Parent Item: DSI 9342-013

Parent Item Name: Gusset Repair, Quick Release

Start Date: 5/15/2012

Required Date: 5/16/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3929-041 Gusset Assembly | | Manufactured | No | | | 110 | Each | 11.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA005 | | 11 | | | | | | | |
| | | | | 77675 | | 2 | | | | | | | |
| | | | | 79152 | | 8 | | | | | | | |
| | | | | 81255 | | 1 | | | | | | | |
| D3929-042 Gusset Assembly | | Manufactured | No | | | 110 | Each | 13.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA005 | | 13 | | | | | | | |
| | | | | 77677 | | 4 | | | | | | | |
| | | | | 79154 | | 8 | | | | | | | |
| | | | | 81254 | | 1 | | | | | | | |
| BLRS-020 Pip Pin | | Purchased | No | | | 110 | Each | 19.0000 | 4 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST283 | | 19 | | | | | | | |
| | | | | 120809 | | 3 | | | | | | | |
| | | | | 121322 | | 16 | | | | | | | |

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14

REF. FAA STC: SR00213NY

REF. EASA STC: EASA.IM.R.S.01405

REFERENCE ONLY

IN CASES WHERE THE D2325 GUSSETS HAVE SUSTAINED CONSIDERABLE DAMAGE, DSI 9342-011/-013 REPAIR KITS CAN BE PROCURED FROM DART TO REWORK EXISTING D350-607-041/-043 BASKET BASES ONLY. D350-607-045/-047 BASKET BASES CANNOT BE REWORKED TO THIS PROCEDURE. REPLACE THE D2325 GUSSETS BY T.I.G. WELDING AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC...
- 2) REMOVE EXISTING D2325 GUSSET(S) AS SHOWN IN FIGURE 1.
- 3) INSTALL REPLACEMENT D3929-041/-042 GUSSETS BY T.I.G. WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD AS SHOWN IN FIGURE 2.
- 4) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607 REV 0.
- 5) WHEN BASKET BASE IS REPAIRED, LONGER BOLTS OR QUICK RELEASE PINS ARE REQUIRED TO INSTALL THE BASKET ON AIRCRAFT. SUBSTITUTE EXISTING HARDWARE USING PARTS LISTED BELOW.
- 6) ADJUST WEIGHT AND BALANCE IN ACCORDANCE WITH THE TABLE ON SHEET 4.

PARTS LIST

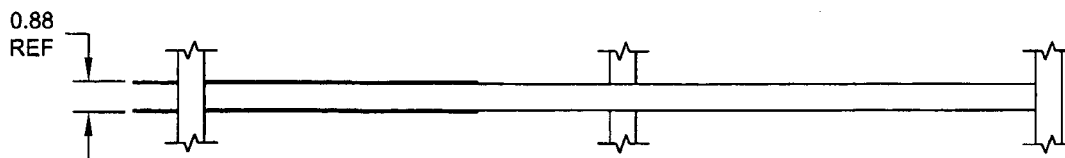
| QTY. -011 | QTY. -013 | PART NUMBER | DESCRIPTION |
|--------------|--------------|--------------|---------------------------------------|
| X | | DSI 9342-011 | GUSSET REPAIR KIT |
| | X | DSI 9342-013 | GUSSET REPAIR KIT, QUICK RELEASE |
| 2 | 2 | D3929-041 | GUSSET ASSY, LH |
| 2 | 2 | D3929-042 | GUSSET ASSY, RH |
| 4 | | AN4-15A | BOLT (REPLACES AN4-12A) |
| 8 | | AN960JD416 | WASHER |
| | 4 | BLRS-020 | QUICK RELEASE PIN (REPLACES BLRS-010) |
| 4 | | MS21042L4 | NUT |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

| | | | |
|------------|--|--|--------------|
| B | CREATION OF DSI KITS TO PROVIDE REPLACEMENT PARTS AND REQD HARDWARE. SEE NCR#09-042. | MB | 09.04.06 |
| A | NEW ISSUE | PH | 06.07.10 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | B | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9342 | SHEET 1 OF 4 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | BASKET BASE WELD REPAIR | NTS |
| DATE | 09.04.06 | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



REFERENCE ONLY

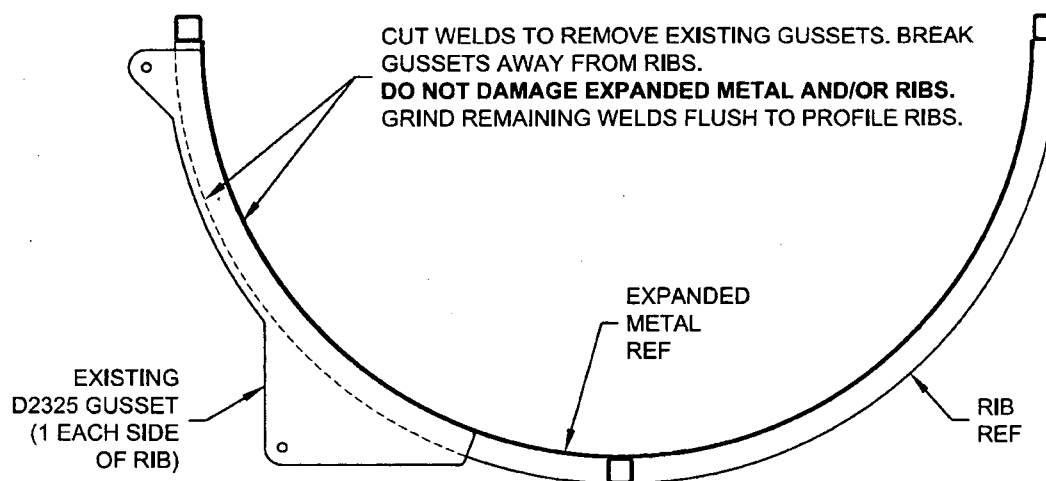


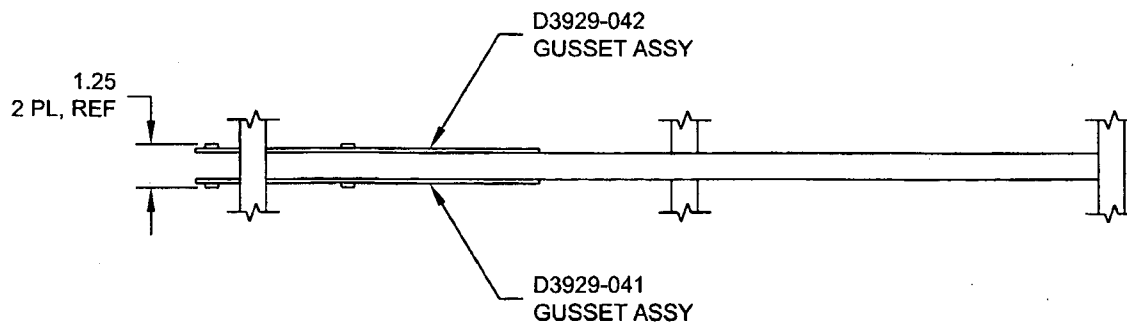
FIGURE 1 - REMOVAL OF EXISTING D2325 GUSSETS
(ON D350-607-041/-043 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

| | | | |
|------------|-----------|--|--------------|
| DESIGN | <i>PH</i> | DART AEROSPACE LTD | |
| DRAWN | <i>B</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9342 | SHEET 2 OF 4 |
| APPROVED | <i>PH</i> | TITLE | SCALE |
| DE APPR. | <i>PH</i> | BASKET BASE WELD REPAIR | NTS |
| DATE | 09.04.06 | <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



REFERENCE ONLY

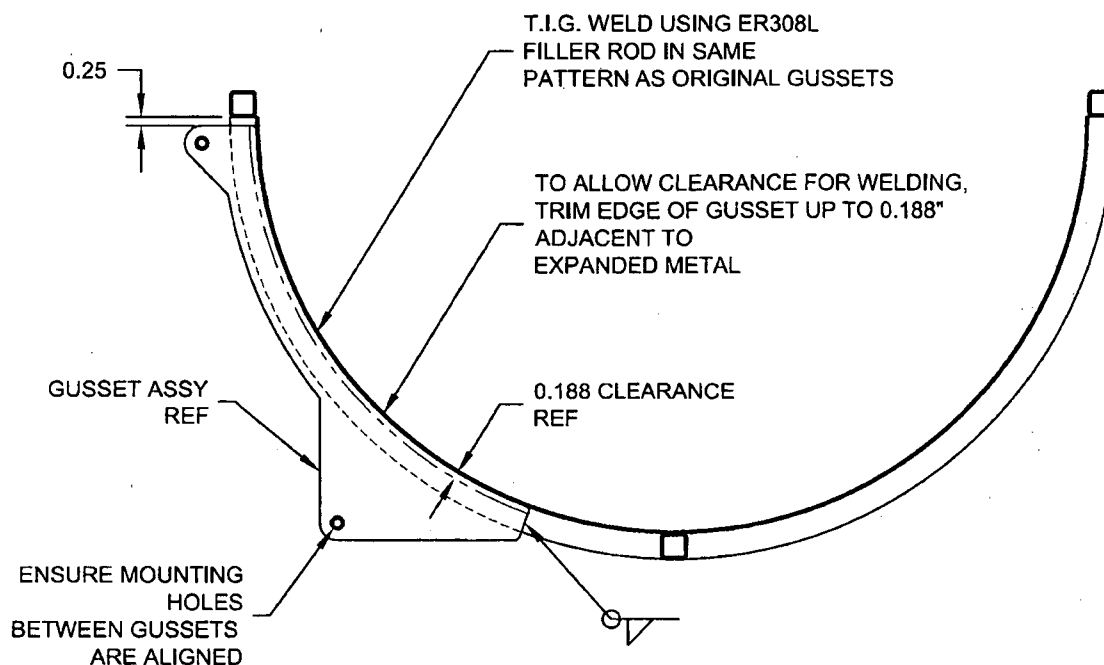


FIGURE 2 - INSTALLATION OF REPLACEMENT D3929-041/-042 GUSSETS
(ON D350-607-041/-043 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | <i>PH</i> | DART AEROSPACE LTD | |
| DRAWN | <i>B</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9342 | SHEET 3 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BASKET BASE WELD REPAIR | NTS |
| DATE | 09.04.06 | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

REFERENCE ONLY

FOR D350-607-041 AT CHG 008, D350-607-043 AT CHG 005, AND D350-607-045/-047 AT CHG 003 AND SUBSEQUENT, THE INTENT OF DSI 9342 HAS BEEN INCORPORATED DURING MANUFACTURE. AMEND WEIGHT AND BALANCE AS OUTLINED BELOW. ALSO, THE PARTS LIST HAS BEEN AMENDED AS FOLLOWS:

| QTY. -041 | QTY. -043 | QTY. -045 | QTY. -047 | PART NUMBER | DESCRIPTION |
|--------------|--------------|--------------|--------------|--------------|-----------------------------|
| X | | | | D350-607-041 | HELI-UTILITY BASKET |
| | X | | | D350-607-043 | HELI-UTILITY BASKET |
| | | X | | D350-607-045 | HELI-UTILITY BASKET (SHORT) |
| | | | X | D350-607-047 | HELI-UTILITY BASKET (SHORT) |

IS:

| | | | | | |
|----|----|-----|-----|------------|--------|
| 1 | 1 | 1 | 1 | AN4-12A | BOLT |
| 4 | 4 | 4 | 4 | AN4-15A | BOLT |
| 28 | 40 | 30* | 42* | AN960JD416 | WASHER |

*: EXTRA WASHERS REQUIRED TO MOUNT LID ON BASE DUE TO INCREASED THICKNESS OF GUSSETS AT BOTH ENDS OF BASKET BASE. LOCATE WASHERS BETWEEN BASE HINGE PLATE AND D2022-101 SPACER, TYPICAL BOTH ENDS.

WAS:

| | | | | | |
|----|----|----|----|------------|--------|
| 5 | 5 | 5 | 5 | AN4-12A | BOLT |
| 28 | 40 | 28 | 40 | AN960JD416 | WASHER |

WEIGHT & BALANCE






| INSTALLATION | WEIGHT | LATERAL | | LONGITUDINAL | |
|---|--------------------|-------------------|---------------------------|------------------|-----------------------------|
| | | ARM | MOMENT | ARM | MOMENT |
| D350-607-041/-043 AT CHG 008/005 HELI-UTILITY BASKET | 89.6 lb 40.6 kg | ±48 in ±1.22 m | ±4301 in-lb ±49.5 m-kg | 135 in 3.43 m | ±12096 in-lb ±139.3 m-kg |
| D350-607-045/-047 AT CHG 003 HELI-UTILITY BASKET (SHORT) | 66.6 lb 30.2 kg | ±48 in ±1.22 m | ±3197 in-lb ±36.8 m-kg | 135 in 3.43 m | ±8991 in-lb ±103.6 m-kg |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

| | | | |
|------------|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN |  | | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9342 | SHEET 4 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET BASE WELD REPAIR | NTS |
| DATE | 09.04.06 | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |